

Date: Friday, 12/21/2007 7:27:31 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	STRUT	
Job Number	36514				
Estimate Number	10955				
P.O. Number	N/A		Part Number	D2565201	
This Issue	12/21/2007	S.O. No.	Drawing Number	D2565 REV E	
Prsht Rev.	NC		Project Number	N/A	
First Issue	N/A	Type	Drawing Revision	E	
Previous Run	36366		Material	N/A	
Written By			Due Date	1/20/2008	Qty: 10 Um: Each
Checked & Approved By	9/07/2008				
Comment	Est: D 01.06.04 Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304TR0750W049	304 RD Tube .750 x .049W 88 08/01/10 (10)
		Comment: Qty.: 2.0124 f(s)/Unit Total : 20.1243 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049) Batch No: M105988 (8) 1106015 (2)
2.0	BRAKE NC	NC BRAKE 88 08/01/10 (10)
		Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 88 08/01/10 (10)
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill hole as per Dwg D2565 (one end only) Deburr
4.0	QC5	INSPECT WORK TO CURRENT STEP 88 08/01/10 (10)
		Comment: INSPECT WORK TO CURRENT STEP
5.0	POWDER COATING	POWDER COATING M106379 88 08/01/10 (10)
		Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: 1D Date: 08/01/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 36514		Part Number: D2565201
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION  <i>(10)</i>
Comment: INSPECT POWDER COAT <i>BL 0801-12</i>		
7.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>ST270</i>		<i>PC 8/1/14 (10)</i>
8.0	QC21 	FINAL INSPECTION/W/O RELEASE  <i>(10)</i>
Comment: FINAL INSPECTION/W/O RELEASE <i>HD 8/1/15</i>		
Job Completion 		<i>U 28.01.15</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

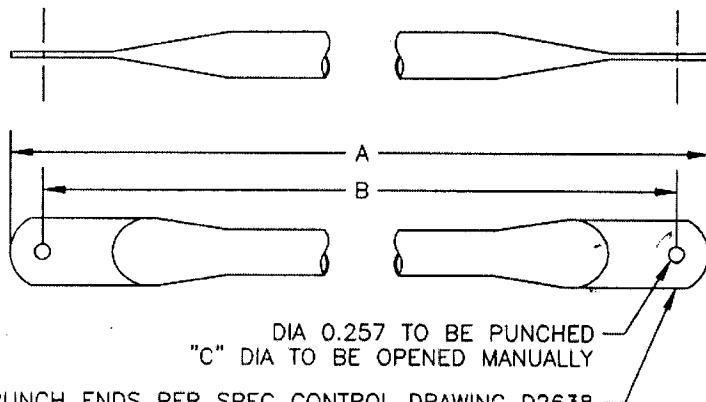
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO. D2565 REV. E SHEET 1 OF 1		
DATE 04.05.05		TITLE STRUT SCALE 1:3		
A	96.05.03	NEW ISSUE		
B	97.03.15	CORRECT D2565-111 DIM. A		
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)		
D	02.06.05	ADD -3XX PARTS; ADD FINISH		
E	04.05.05	ADD D2565-401-411; RMV ANGLE D		

RELEASED  
04.05.05



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF. DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

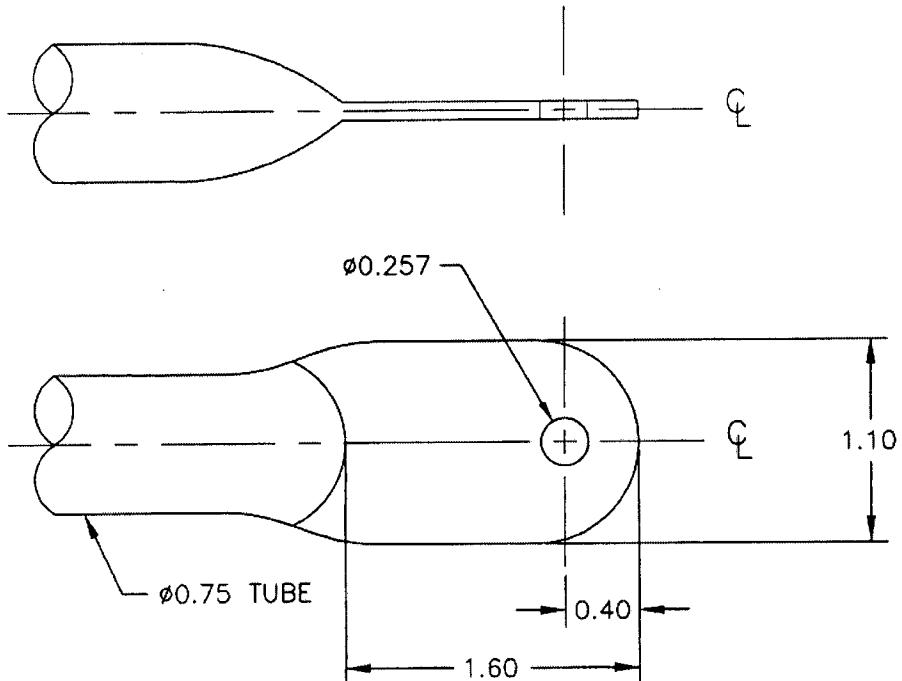
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WORK ORDER  
NO 36574

**DART**

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED M	APPROVED J	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
	A	98.04.28	NEW ISSUE

**RELEASED**  
07/05 KE

## SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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